

7/5/23

SPLIT

DART AEROSPACE LTD	Work Order:	23427 R
Description: Lug Clamp BC over. 47	Part Number:	D3041-1
Drawing: D3041 Rev. A	Qty:	254

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	JG	05.05.26	25
2	METAL	Cut blanks: 1.250 long Material: D2423 Lug extrusion	Batch: B21202	SD	05.05.26 25
3	HAAS	Machine per folio FA153 Issue 10 200804 Check for crack while loading into the machine	LG	05.05.26	25
4	QC	Inspect Level 2 Receive & Inspect for transit damage	CL	05.06.07	26
5	QC	Inspect Level 5	JW	05.06.07	26
6	METAL	Tumble and deburr rough edges after tumbling <i>N/A</i> if applicable	ML	05.06.07	26
7	METAL	Acid etch and Alodine per QSI 005 4.1	ML	05.06.07	26
8	METAL	Inspect Level 5	ML	05.06.07	26
9	FINISHING	Mask inside of 0.8120" dia. Hole	ML	05.06.07	26
10	FINISHING	Powder Coat White (ref. 4.3.5.1) per QSI 005 4.3	ML	05.06.07	26
11	QC	Pick: Qty Part number Description batch 1 D2611 Bearing B15586	SB	05/06/07	4
12	QC	Press D2611 bearing into lug as per dwg D3041	SB	05/06/07	4
13	QC	Stake bearing into place as per dwg D3041	SB	05/06/07	4
14	QC	Inspect Level 7	Z	05.06.07	4
15	STORES	Identify and stock	Y	05.06.07	4
16	EXPEDITING	Close W/O 47.42 Job Cost / Part 32.095	JG	05/06/07	4

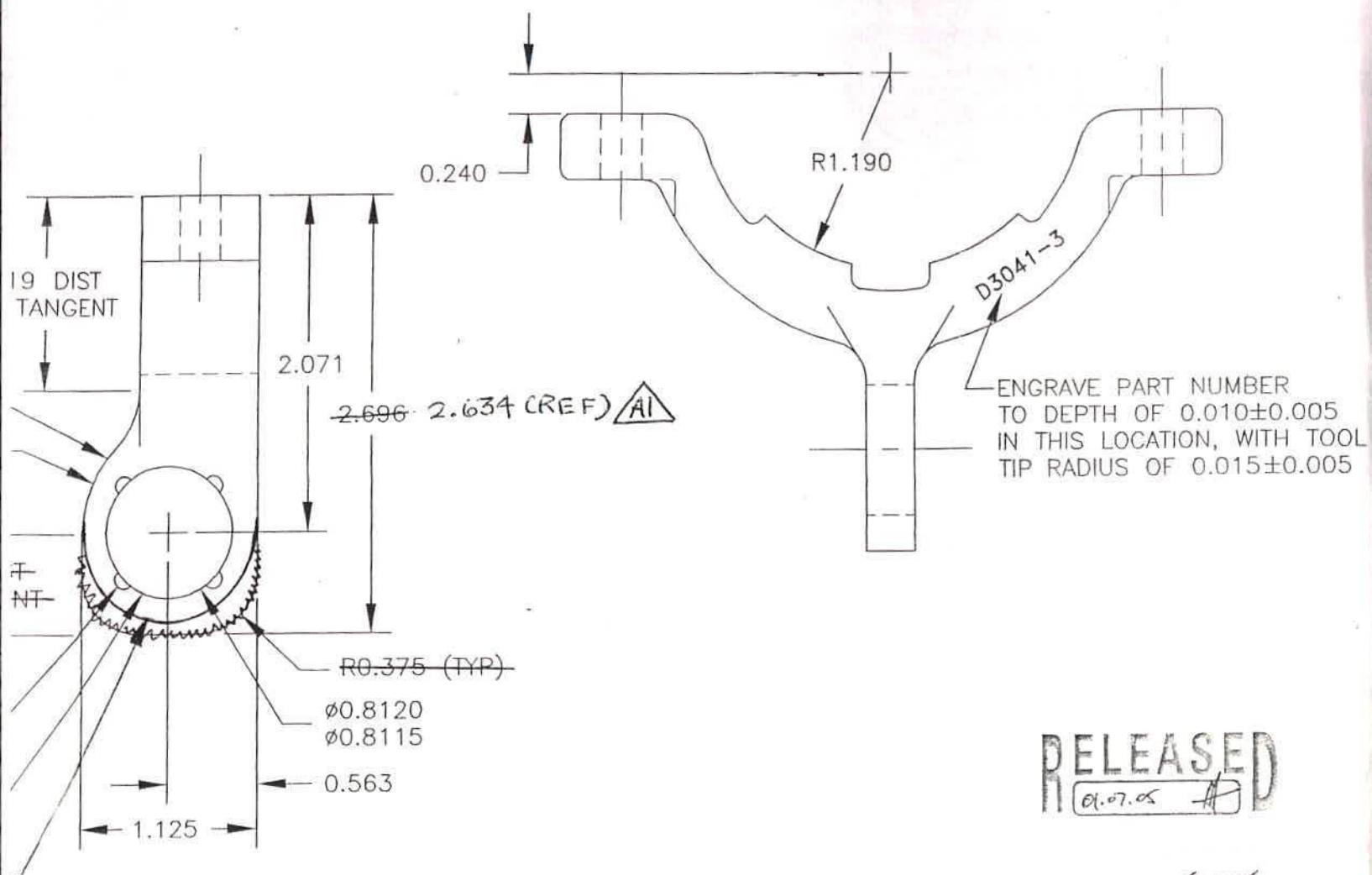
Rev	Date	Change	Revised By	Approved
A	01.07.11	New Issue	SM	RC

RELEASED

EE 01.07.11

D3041-3

SAME AS D3041-1 EXCEPT AS SHOWN



RELEASED
01.07.05

UNDER REVIEW
AP 01.07.11

D3041-1 & D3041-3 CLAMPS

- 1) MANUFACTURE FROM EXTRUSION D2423
- 2) PART IS SYMMETRIC ABOUT CENTERLINE
- 3) BREAK ALL SHARP EDGES 0.010–0.020
- 4) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 5) STAKE D2611 BEARING AFTER POWDER COAT
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ISSUED
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A	01.06.28		NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	PORT HADLOCK, WA
DATE		TITLE	REV.
01.06.28		CLAMP	SHEET 1 OF 1